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D119-796-141TRN
Job Sheet 198918



Part No: D119-796-141TRN

Job Qty: 1 pcs

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 8/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D119-796-141 REV H IPP REV A RQ 14/06/06 VERIFIED BY DD IPP REV:B 16.05.04 AS PER DWG REV.H
DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier				
100	Mori Seiki TL-40 - 1	1 pcs		8/21/19	1.00	1.52	Mori Seiki TL-40 - 1				662019-08-20 9-89
110	QC 2	1 pcs		8/21/19	0.00	0.00	QC 2 - 1				
							QC 2 - 12				
							QC 2 - 14				
							QC 2 - 17				
							QC 2 - 19				
							QC 2 - 2				
							QC 2 - 20				
							QC 2 - 22				
							QC 2 - 23				
							QC 2 - 25				
							QC 2 - 32				
							QC 2 - 33				
							QC 2 - 35				
							QC 2 - 39				
							QC 2 - 4				
							QC 2 - 40				
							QC 2 - 44				
							QC 2 - 45				
							QC 2 - 48				
							QC 2 - 49				
							QC 2 - 50				
							QC 2 - 51				
							QC 2 - 52				
							QC 2 - 57				
							QC 2 - 62				
							QC 2 - 63				
							QC 2 - 8			DAS	
							QC 2 - 66			662019-08-20	
							QC 2 - 64			9-89	

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	Mori Seiki TL-40 - 1 - B4B	1	8/21/19	1.00 1.52	Mori Seiki TL-40 - 1 - B4B	DAS 662019-08-22 9-89
	pcs					
130	QC 2	1	8/21/19	0.00 0.00	QC 2 - 1	
	pcs				QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	DAS 662019-08-22 9-89
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	QC 8	1	8/21/19	0.00 0.00	QC 8 - 12	
	pcs				QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	

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170 Packaging 3-1 - Stock - B4B	1 pcs	8/21/19	0.00 0.00	QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	JW 19-10-11
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - FG	1 pcs	8/21/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - FG - 53	9-55

OCT 1 1 2019

Part Op 100 - 1-Fill tube with sand & install plugs on both ends as per Folio FB316 2-Turn first side as per Folio FB316 3-Blend
 Descriptions: transition lines only, **do not sand whole tube**: FOLIO REV: H DWG REV: H *Use mill bastard
 file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.
 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - 1-Turn second side as per Folio FB316 2-Blend transition lines only, **do not sand whole tube**: 3-Remove sand
 and plugs 4- scribe batch # and part # as per dwg
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
 150 - 1- handfinish X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT. USE RED
 SCOTCH BRITE
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG014
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6024-103	Crosstube Material	1 pcs (1 ea)	100-Mori Seiki TL-40 - 1	F150-732

8/7/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Mori Seiki TL-40 - 1	D6024-103	1	7	0
Part Specifications				
Specifications could not be found.				



Container No: S207116



Part: D119-796-141TRN

Job No: 198918

Serial No/Batch: S207116

Revision: H

Inspector:

Exp Date:

Instructions:

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Date: 08/20/19

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DART AEROSPACE LTD	Work Order:	198918
Description: Crosstube Assembly (AW119 MKII Fwd)	Part Number:	D119-796-141TRN
Inspection Dwg: D119-796-141 Rev: H		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	6.00	+/-0.030	6.005	✓		CNC-08	
	2.516	+/-0.005	2.521	✓		CNC-04	
	2.333	+0.005/-0.000	2.337	✓		↓	
	2.333	+0.005/-0.000	2.338	✓			
	2.408	+0.005/-0.000	2.413	✓			
	2.502	+0.005/-0.000	2.506	✓			
	2.596	+0.005/-0.000	2.601	✓			
	2.596	+0.005/-0.000	2.601	✓			
SIDE B	6.00	+/-0.030	5.999	✓		CNC-08	
	2.516	+/-0.005	2.521	✓		CNC-04	
	2.333	+0.005/-0.000	2.338	✓		↓	
	2.333	+0.005/-0.000	2.338	✓			
	2.408	+0.005/-0.000	2.413	✓			
	2.502	+0.005/-0.000	2.507	✓			
	2.596	+0.005/-0.000	2.601	✓			
	2.596	+0.005/-0.000	2.601	✓			
	102.26	+/-0.020	102.26	✓		Tape	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
 Scrap ☐ ☐ ☐
 Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Cross tube ☐ ☐ ☐
 Small Fab ☐ ☐ ☐
 Finishing ☐ ☐ ☐
 Skid-tube ☐ ☐ ☐
 Machining ☐ ☐ ☐
 Large Fab ☐ ☐ ☐

Engineering ☐ ☐ ☐
 Water Jet ☐ ☐ ☐
 Supplier ☐ ☐ ☐
 Quality ☐ ☐ ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
 Manufacturing Process ☐ ☐ ☐
 Equip/Tooling ☐ ☐ ☐
 Handling/Preservation ☐ ☐ ☐
 Material ☐ ☐ ☐
 Product Improvement ☐ ☐ ☐
 Process Improvement ☐ ☐ ☐
 Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____